

**We claim:**

- 1. A magnetic recording medium comprising:  
a substrate;  
a first bcc underlayer formed on said substrate;  
a second bcc underlayer formed over the first underlayer, said second underlayer comprising boron;  
a third bcc underlayer formed over the second bcc underlayer; and  
a magnetic alloy data recording layer.**
- 2. Medium of claim 1 wherein said first, second and third underlayers comprise bcc Cr alloys, and magnetic alloy data recording layer comprises a hcp Co alloy.**
- 3. Medium of claim 2 wherein said first and third underlayers substantially lack boron.**
- 4. Medium of claim 2 wherein said first and third underlayers comprise less than 1% boron.**
- 5. Medium of claim 1 wherein said boron in said second underlayer causes grain separation in said magnetic alloy data recording layer.**
- 6. Medium of claim 1 wherein said boron in said second underlayer causes a reduction in grain size in said magnetic alloy data recording layer.**

7. Medium of claim 1 wherein said boron reduces noise in said magnetic recording medium.
8. Medium of claim 1 further comprising a nucleation layer formed between said third underlayer and said magnetic alloy data recording layer.
9. Medium of claim 1 further comprising an amorphous metallic layer between said substrate and said first underlayer.
10. Medium of claim 1 further comprising a coupling layer formed on said magnetic alloy data recording layer and a second magnetic layer formed on said coupling layer, wherein said magnetic alloy data recording layer and said second magnetic layer are antiferromagnetically coupled to each other.
11. A magnetic disk drive comprising the magnetic recording medium of claim 1.
12. A magnetic recording medium comprising:
  - a substrate;
  - a first underlayer comprising Cr formed on said substrate;
  - a second underlayer comprising Cr and at least one additive formed on said first underlayer;
  - a third underlayer comprising Cr formed on said second underlayer; and

a magnetic alloy data recording layer formed on said third underlayer, said additive causing grain separation in said magnetic alloy data recording layer.

13. Medium of claim 12 wherein said first, second and third underlayers have a bcc crystal structure and said magnetic alloy data recording layer comprises a hcp Co alloy, and said first and third underlayers substantially lack said additive.

14. Medium of claim 12 wherein said additive reduces noise and grain size in said magnetic alloy data recording layer.

15. Medium of claim 12 further comprising a nucleation layer formed between said third underlayer and said magnetic alloy data recording layer

16. Medium of claim 12 further comprising an amorphous metallic layer between said substrate and said first underlayer.

17. Medium of claim 12 further comprising a coupling layer formed on said magnetic alloy data recording layer and a second magnetic layer formed on said coupling layer, wherein said magnetic alloy data recording layer and said second magnetic layer are antiferromagnetically coupled to each other.

18. A magnetic disk drive comprising the magnetic recording medium of claim 12.

19. A magnetic recording medium comprising:
- a substrate;
  - a first underlayer comprising Cr formed on said substrate;
  - a second underlayer comprising Cr and at least one additive formed on said first underlayer;
  - a third underlayer comprising Cr formed on said second underlayer; and
  - a magnetic alloy data recording layer formed on said third underlayer, said additive causing grain size reduction in said magnetic alloy data recording layer.
20. Medium of claim 19 wherein said first, second and third underlayers have a bcc crystal structure and said magnetic alloy data recording layer comprises a hcp Co alloy, and said first and third underlayers substantially lack said additive.
21. Medium of claim 19 further comprising a nucleation layer formed between said third underlayer and said magnetic alloy data recording layer.
22. Medium of claim 19 further comprising an amorphous metallic layer between said substrate and said first underlayer.
23. Medium of claim 19 further comprising a coupling layer formed on said magnetic alloy data recording layer and a second magnetic layer formed on said coupling layer, wherein said magnetic alloy data recording layer and said second magnetic layer are antiferromagnetically coupled to each other.

24. A magnetic disk drive comprising the magnetic recording medium of claim 19.